

Work Order ID 84805

84805

Page 1

Item ID: D206-628-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step LH

Stop ***NS2***

Start Date: 23/05/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/23

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

E SP

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-011 CHG 003

S 12/07/10

OK for CL 12/7/10

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

3

12/07/06 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

S 12/6/10

x3

LH

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 23/05/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-

011Location: _____

PPP Rev: F

3x

SP
127/0

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

CK 12/7/11

012-07-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84805

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Parent Item: D206-628-011

D206-628-011

Parent Item Name: Heli-Access-Step LH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2721-041		Manufactured	No			110	Each	0.0000	3	3			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2721-041

206B Step Assembly

D2731-7		Manufactured	No			110	Each	72.0000	12	12			
---------	--	--------------	----	--	--	-----	------	---------	----	----	--	--	--

D2731-7

Mounting Lug

Location	Loc Qty	Loc Code
----------	---------	----------

ST	-50	
----	-----	--

ST468A	4	
--------	---	--

71860	4	
-------	---	--

ST469	118	
-------	-----	--

78922	68	
-------	----	--

D2732-030		Manufactured	No			110	Each	2.0000	8	24			
-----------	--	--------------	----	--	--	-----	------	--------	---	----	--	--	--

D2732-030

Rubber Cushion

Location	Loc Qty	Loc Code
----------	---------	----------

ST402	2	
-------	---	--

76850	1	
-------	---	--

81499	1	
-------	---	--

D3394-043		Manufactured	No			110	Each	112.0000	12	12			
-----------	--	--------------	----	--	--	-----	------	----------	----	----	--	--	--

D3394-043

Lug Assembly

Location	Loc Qty	Loc Code
----------	---------	----------

ST479	112	
-------	-----	--

78921	32	
-------	----	--

80217	60	
-------	----	--

82760	20	
-------	----	--

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 84805

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Parent Item: D206-628-011

D206-628-011

Parent Item Name: Heli-Access-Step LH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 3.00

Required Qty: 3.00

AN4-13A

Purchased

No

110

Each

1,513.000



12



AN4-13A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST357

1513

119449

33

120187

19

120422

2

120770

394

121162

65

121652

1000

AN4-14A

Purchased

No

110

Each

344.0000



12



AN4-14A

Bolt

**

JB

12/07/06

Location

Loc Qty

Loc Code

357

100

121349

100

ST357

244

120187

13

120769

1

121068

17

121444

100

121708

113

121349

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 84805

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Parent Item: D206-628-011

D206-628-011

Parent Item Name: Heli-Access-Step LH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 3.00

Required Qty: 3.00

AN4-15A

Purchased

No

110

Each

591.0000

4

12

AN4-15A

Bolt

**

122141

JB

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

391

118706

3

120422

88

121444

100

121541

200

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

12

36

AN960JD416

Washer

**

121912

JB

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

110

Each

4,414.000

12

36

MS21042L4

Nut

**

121444

JB

12/07/06

Location

Loc Qty

Loc Code

ST300

4414

119075

125

121011

1032

121444

2957

121652

300

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Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

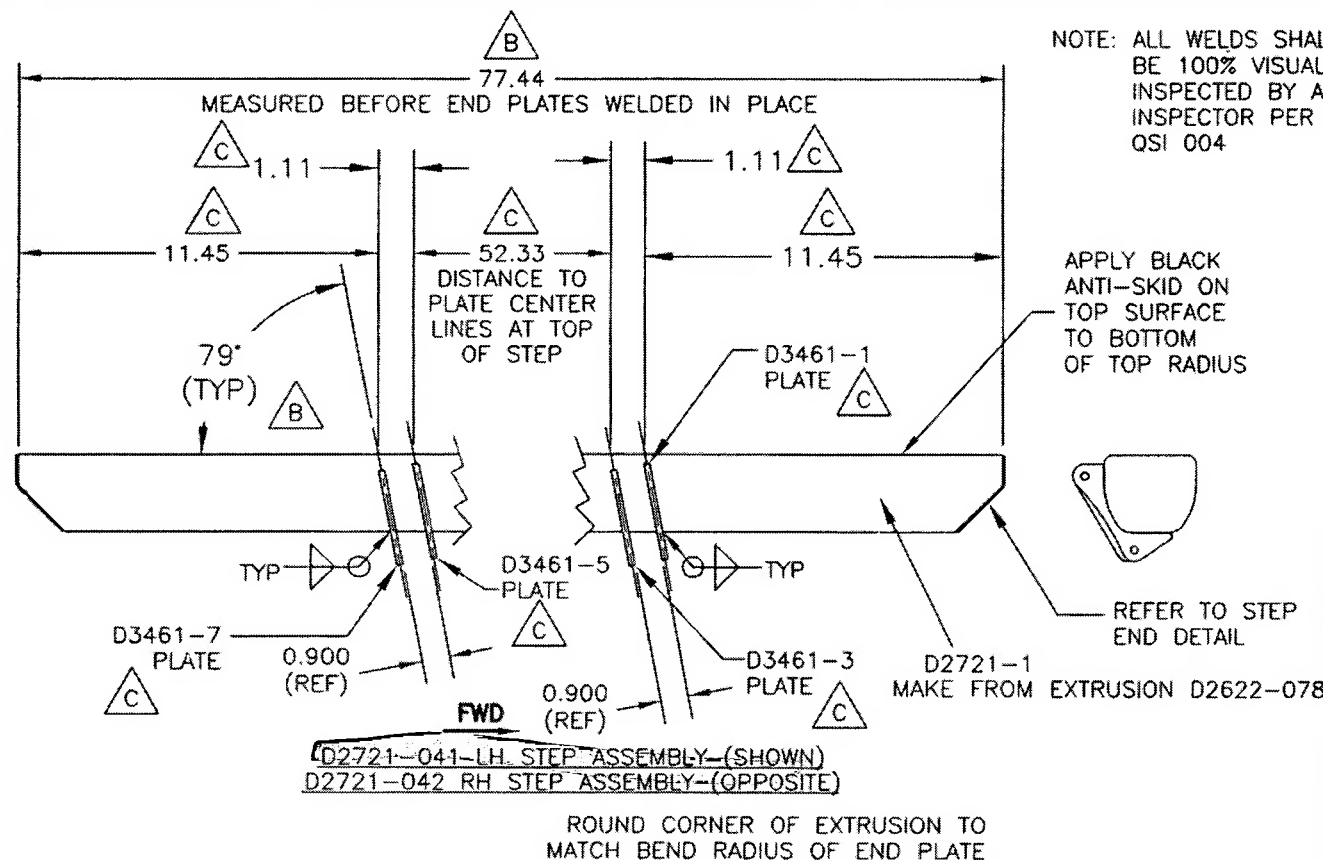
Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
/ 1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
/ 4	4	4	4			D2731-7	MOUNTING LUG
/ 8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
/ 4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
/ 4	4			4	4	AN4-13A	BOLT
/ 4	4	4	4	4	4	AN4-14A	BOLT
/ 4	4	8	8	4	4	AN4-15A	BOLT
/ 12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
/ 12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

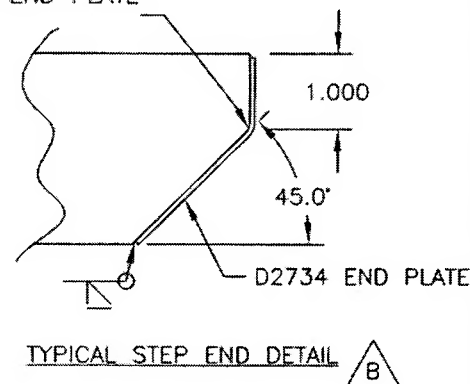


D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
X	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2721	206B STEP ASSEMBLY
A	97.12.04	NEW ISSUE		
B	98.10.19	79° WAS 80° UPDATED WELD DETAIL REVISED TOLERANCES, 53.44 WAS 54.0		
C	05.09.19	RE-DESIGN, ADD D3461-1/-3/-5/-7		
SCALE	NTS			
SHEET 1 OF 1				